

split
Work Order ID 64892-2

December 22, 2010 7:11:46 AM

Item ID: D3136-041

Revision ID:

Item Name: Window Assembly

Start Date: 12/21/10 Start Qty: 6.00

Required Date: 12/23/10 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Accept

Tooling:

SPC (Y/N):



Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3136

Rev E

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: 5

2-Deburr if necessary

0.00

0.00

0.00

0.00

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

Accept



Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

10-12-22

10-12-22

Scrap (X1)

(X7)

Pto ->

(X7)

(X2)

5/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: _____ Fault Category: (2) (1) Small Parts Thermoflex NCR: Yes No DQA: _____ Date: 11.01.10
 Resolution: (1) & 2 Scrap Disposition: 1 & 2 Scrap QA: N/C Closed: ✓ Date: 11/01/11

NCR: 64892		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(1) 10/12/22	# 160	Found At inspection that Qty of (1) were cut to the minimum Dim (25.46", 22.68" should be 25.50±.03, 22.63 ±.030). windows need to be		- Replace Qty of (1) windows in 11533E (2) Re make window to make allable to	18/10/22	S 10/12/22		S 10/12/22
		At normal to avoid complab. R.L. Jet needs to be replaced.		- stock mat. under original to be For use for smaller window				S 10/12/22
(2) 11/01/04	# 130	Window has small warping along one side R.L. Press from thermoflex		- Scrap & Destroy no replace	S 11/01/04			S 11/01/04

NOTE: Date & initial all entries

Work Order ID 64892

December 22, 2010 7:11:47 AM

Page 2

Item ID: D3136-041

Accept

Revision ID:

Item Name: Window Assembly

Start Date: 12/21/10 Start Qty: 6.00

Required Date: 12/23/10 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

1-Thermoform as per Dwg D3136 and Folio FTA006 Dwg
Rev. E Folio Rev. C 12- Engrave Part # and
Batch # , and affix labels (D3108-9)

0.00

0.00

x7

Whe
10/12/22

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

x7

Whe
10/12/22

150



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Scrap (TV)

Pho
Previous
Page

Work Order ID 64892

December 22, 2010 7:11:48 AM



Page 3

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 12/21/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/23/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Water sand and buff to remove scratches as required

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect edge and window deformation, wrap in plastic

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Scrap

Work Order ID 64892

December 22, 2010 7:11:48 AM



Page 4

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 12/21/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/23/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SCRAP

MF
~~10-13~~
11-01-04

Picklist Print

December 22, 2010 7:11:45 AM

Page 1

Work Order ID: 64892

Parent Item: D3136-041

Parent Item Name: Window Assembly



Start Date: 12/21/10

Required Date: 12/23/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 04.02.04 Reformat KJ/DS
IPP C Thermoform in house 05/07/2007 DL
IPP D Rev E 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3108-9

Manufactured

No

100

Each

642.0000

2

12



Decal

Location

Loc Qty

Loc Code

ST036

642

34554

142

46546

500

14

MACRLICS.125

Purchased

No

170

sf

230.3222

4.25

26.84211



1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT

230.3222

113204

4

113861

10.4

114673

9.6722

115338

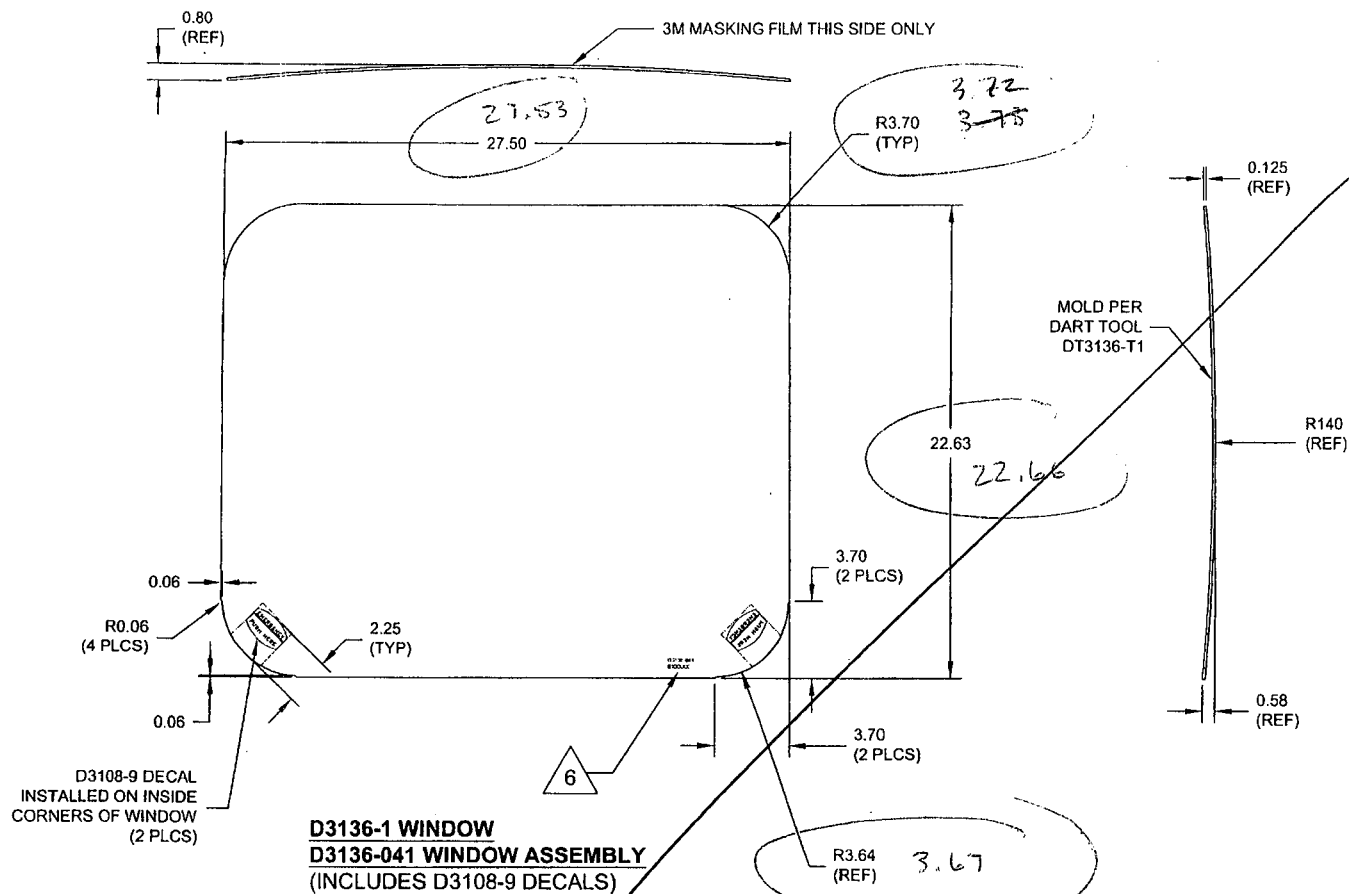
206.25

115338

1810-12-22

7

SLAD



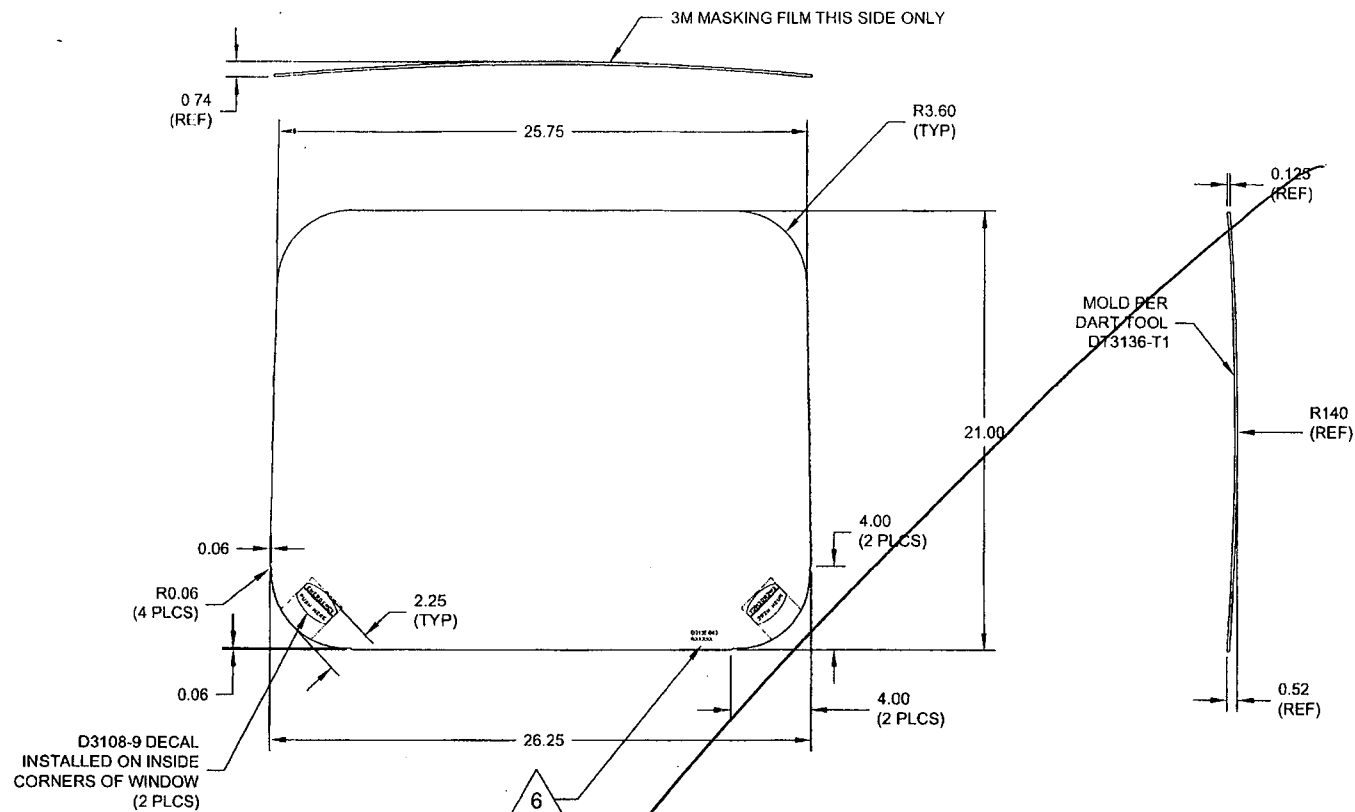
NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6

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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QST 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250°F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS


RELEASED
 07.09.22

DESIGN	4	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	D3136	SHEET 2 OF 2
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	WINDOW ASSEMBLY	1:
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64842

☒ **First Article** ☐ **Prototype**

Measured by:	HB
Date:	10-6-02

Audited by:	
Date:	10/12/27

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue P/O D3136-041	KJ/DD	

